

Alh, 628 0654

Work Order ID 68251

Monday, April 11, 2011 10:29:51 AM



Page 1

Item ID: D2743

Accept



Setup Start



Revision ID:

Stop



Item Name: Crossbolt Spacer

Start Date: 4/11/2011 Start Qty: 60.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 60.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-04-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2743	Rev B								

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA202 & DWG D2743

FOLIO REV:

DWG REV:

[Signature] 11/4/25

2-DEBURR AS REQUIRED

64 *[Signature]*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

[Signature] 11/4/25

64 *[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68251

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Page 2

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Accept



Setup Start



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Stop



Item Name: Crossbolt Spacer

Start Date: 4/11/2011 Start Qty: 60.00



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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

*AL 11-4-25**64**0*

QC

Memo

0.00

Quality Control

130

0.00



Skidtubes

Memo

0.00

*64**0**BE 11/04/29*

Skidtubes

1- Clean crossbolt spacer with ultra bright aluminum cleaner

160

Identify as per dwg & Stock Location: *LG*

0.00



Packaging

Memo

0.00

*64**0**BE 11/04/29*

Packaging

STOCK IN SKIDTUBE CELL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






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Work Order ID 68251

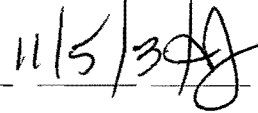
Page 3

Monday, April 11, 2011 10:29:51 AM

Item ID: D2743 Accept  Setup Start 
Revision ID: Stop 
Item Name: Crossbolt Spacer
Start Date: 4/11/2011 Start Qty: 60.00  Cust Item ID:
Required Date: 4/14/2011 Req'd Qty: 60.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

11/5/39 
H 11-04-29
(64)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Monday, April 11, 2011 10:29:58 AM

Page 1

Work Order ID: 68251



Parent Item: D2743



Parent Item Name: Crossbolt Spacer

Start Date: 4/11/2011

Required Date: 4/14/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP ☐ E ☐ 05.04.13 ☐ Reformat; removed tumble and deburr step ☐ KJ/JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.625W.065		Purchased	No			100	f	24.0000	0.2667	16.84421			



6061-T6 RD Tube .625 x.065W



~~11/4/25~~

Location

Loc Qty

Loc Code

MAT014
117328

24
24

18 ft

W/O:		WORK ORDER CHANGES					
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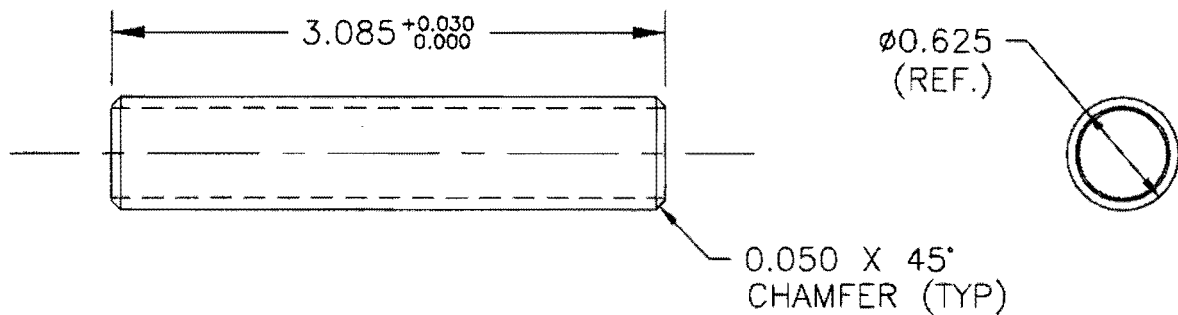


DESIGN <i>[Signature]</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>KE</i>	DRAWING NO. D2743	REV. B SHEET 1 OF 1
DATE 98.12.08		TITLE CROSS BOLT SPACER SCALE 1:1	
A	98.04.16	NEW ISSUE	
B	98.12.08	3.085 WAS 3.060	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68251

RELEASED
98.2.16 DS

AL 11-04-11



MATERIAL: 6061-T6 (WW-T-700/6) 0.625 DIA. X 0.065 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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